## Work Order ID 87916

July-18-12 10:2	6:23 AM			41h"					Page I
Revision ID:	D412-698-019 Bearing Overhaul		Accept	*N900040	100	)* <sup>5</sup>	Setup Star Stop	171.	S1* S2*
Start Date: Required Date: Reference:	7/18/12 Start Qty: 2.00 7/18/12 Req'd Qty: 2.00		*2* *2*	Cust Item ID: Customer:					
Approvals:	Process Plan:QC:	Date:	Tooling: SPC (Y/N):	Date:		1	Run Star Stop	"	R1* R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100			0.00						
*100*	DOCUMENT CONT	ROL					MLJ	12/03	7/18
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110	Pick Kit		0.00						
*110*						2			12/02/15/
Packaging	Memo		0.00	*					12/07/18
Packaging									
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120	QC4- 100% Inspect l	cits for complete	eness 0.00	*					
*120*	<b>M</b>	4.7	0.00			(7)			
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es /	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UPI	DATE			\$
										QA Closed	Date	•
r: _	-				DISPOSITION			Skid-tube	_	EPARTMENT	_	Engineering
o o					Scrap Use-as-is Work Order Update		Thern	Machining	Small Fab Finishing Composite		od. Eng. Coor.	Quality Other
Т				Descri	ption of work order update		Initial	Act	ion	Sign &		
	Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	QC Inspector
		·										
a Ge	35					FAUI	LICAIE	GORT		<del> </del>	<u></u>	
B C C C C H Ir	ending entre No racks rushed/0 uffs eat Trea aspection ipples in	Crimped. t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspect Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/l enance eled d	Unclear	Part Incorro Part Lost/M Part Moved Positioned	ect lissing i Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	g Ge	Date  Date  Gear  Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in	Date Step  Date Step  Gear  Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend	Date Step Qty  Date Step Qty  Gear  Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	g Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty  Description of work order update or Non-conformance  General Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend  DISPOSITION  Rework Scrap Use-as-is Work Order Update or Non-conformance  Description of work order update or Non-conformance  Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Or Non-conformance Chamber of Non-conformance Chamber of Step Other of St	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty  Description of work order update or Non-conformance  FAULT CATE General  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend  DISPOSITION  Rework Scrap Use-as-is Work Order Update  Initial Chief Eng  FAULT CATE General Bend Bend Bend BoM/Route Broken/Damaged Inspect Instruct Countersink Mislabe Countersink Mislabe Cut Too Short Misreae Offset	DISPOSITION  Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update Orange Fab Description Orange O	DISPOSITION  Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance  Bending Centre Not Concentric to O/S BOM/Route Broken/Damaged Cracks C	DISPOSITION  Rework Scrap Use-as-is Work Order Update Date  Date Step Qty Description of work order update or Non-conformance  FAULT CATEGORY  Gear General  Bending Centre Not Concentric to O/S Cacks Broken/Damaged Instructions Incomplete Cross tube Machining Small Fab Processing Processing Composite  FAULT CATEGORY  FAULT CATEGORY  FAULT CATEGORY  Grain Description Ovalized Over/Unde Date  Grain Ovalized Over/Unde Date  Counter Not Concentric to O/S BOM/Route Hardware Over/Unde Date  Crocks Broken/Damaged Instructions Incomplete Part Lost/Not Counters ink Unispection Strip in Tube Counter Short Misread Dorill Holes  OIS AGAINST DEPARTMENT  AGAINST DEPARTMENT  AGAINST DEPARTMENT  Skid-tube Crossstube Machining Small Fab Processing Finishing Crossstube Processing Small Fab Processing Finishing Rec/Sto  Rec/Sto  Crocks Date Machining Small Fab Processing Finishing Cromposite Processing Finishing Rec/Sto  Crocks Date Machining Small Fab Processing Finishing Cromposite Processing Finishing Rec/Sto  Part Movec	DISPOSITION  Rework Scrap Use-as-is Work Order Update Date  Date Step Qty Description of work order update or Non-conformance  Bending Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped.  Centre Not Concentric to O/S Broken/Damaged Crushed/Crimped.  Cracks Broken/Damaged Custon Instructions Incomplete Instructions Incomplete Instructions Incomplete Unclear Part Incorrect Part Incorrect Instructions Incomplete Unclear Part Incorrect Instructions Incomplete Unclear Part Lost/Missing Part Moved Part Moved Power Loss/Surge Ripples in Bend Cities in Bend United Winspection Strip in Tube Cut Too Short Mislabeled Power Loss/Surge Power Loss/Surge Offset

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde July-18-12 10:2		916		*879	16*				,		Page 2	2
Item ID: Revision ID:	D412-698-0	19		Accept	*N900	040	100	)*	Setup	Start	*NS1*	***************************************
Item Name:	Bearing Overl	haul								Stop	*NS2*	
Start Date: Required Date: Reference:	7/18/12 : 7/18/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					141.17	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II 130 *130*	D	Operation Description Packaging		Set Up/ Run Hours 0.00	Teol ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Insp. Number Stamp	22
Packaging Packaging		Memo	nack for shipping as per	0.00 PPP D412-698-019						<u> </u>	<u> </u>	<u></u>
*1 <b>4</b> 0		QC21- Final Inspection	- Work Order Release	0.00					Ļ	165	12/07	118
QC Quality Control		Memo		0.00						. •		1

12-07-18

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NCR:	Yes	/ No				WORK ORDER NON-C		NFORM	MANCE / UPD	ATE			_		
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Work Ord	or.					DISPOSITION				AGAINST DE	ΞP	ARTMENT/	PROCESS		
Part i	•				····	Rework Scrap		Ŋ	Skid-tube Machining	Crosstube Small Fab			Water Jet		Engineering Quality Other
NCR I	No.					Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	<u> </u>	Kec/Stor	e/Packaging Supplier	$\overline{}$	Other
Root					Descri	ption of work order update	1	Initial	Actio	on	Τ	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descri	ption	$\downarrow$	Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling											l				
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Material		.**					l				١				·
Setup															
Otḥer															
Process															
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		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
	L	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
	L	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	nclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge		Other
		Rinnles in	Rond			Drill Holes		Offcot			_				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

87916

Parent Item:

D412-698-019

Parent Item Name:

Bearing Overhaul

**Start Date:** 7/18/12

Required Date: 7/18/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:B 05-10-12 Pick List Revised KJ/JLM

IPP Rev:C 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Status  Issued
0319141		Manufactured	No			110	Each	59.0000	7	14	vg	B
Bolt				Location		Loc Qty	I	Loc Code			T	
				ST235		59	_					
				6696	59	1						8
				7973		4						
				8533		5			2× 82	332		
				8566	50	49			9× 85	660		
3121-241 Bearing Assembly		Manufactured	No			110	Each	118.0000	8	10	18	
				Location		Loc Oty	<u>I</u>	Loc Code			V	,
				ST235A		118						
				6728	30	3			-			
				8484	<b>1</b> 7	106				847		
4				8529	98	9			94 82	-298		- (6)-
31573 Juidé		Manufactured	No	· ip		110	Each	27.0000		2	1B	
•				<b>Location</b>		Loc Qty	Ţ	Loc Code				•
				ST235A		27						`
				7687	73	1						
				7973	35	6			29'	135	1.0	
				8570	00	20						
D3137/5 Washer		Manufactured	No			110	Each	25.0000		2	18	12/07
				Location		Loc Qty	ļ	Loc Code				
				ST235A		3						
				4674	40	3						
				ST235B		22						
				8568	88	22			- <del>-                                  </del>	5688		

NCR:	/es	/ No				WORK ORDER NON-O	O	VFORM	ANCE / UP	DATE				•	<
												QA Closed:	Dat	e:	
Work Orde	or.					DISPOSITION				AGAINST [	EF	PARTMENT	PROCESS		
Part N	٠ ١٥٠					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite		Rec/Stor	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root				_		ption of work order update	1	Initial	Act			Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Descr	iption	4	Date	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									-						
							AUL	T CATE	GORY						
Landi	**	Bending Centre No Cracks Crushed/O Cuffs Heat Trea	Crimped. at		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instruct Mainte Mislabe	on Incomplete ions Incomplete/U nance iled	Jnclear		Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Inspection	•	Tube	-	Cut Too Short	-	Misread	1	Ĺ		Power Loss/	Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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July-18-12 10:26:23 AM

W	ork	Ord	ler	ID:

87916

Parent Item:

D412-698-019

Parent Item Name:

Bearing Overhaul

Purchased

110 Manufactured No

**Start Date: 7/18/12** 

Required Date: 7/18/12

Start Qty: 2.00

12.0000

Required Qty: 2.00



	Lo	cation	Loc Qt	<u>y</u>	Loc Code
	ST	236	1	12	
		77830		1	
		79697		4	
		80903		7	
Purchased	No		110	Each	20.0000

Location	Loc Oty	Loc Code
ST290A	20	
121443	10	
121708	10	

Each

121443

	h			
NCR:	*	Yes	/	No

												DQA:	Dat	e:	•
NCR: 🗽	Yes	/ No					WORK ORDER NON-	COI	NFORI	MANCE / UPDATE		۰ م داء د ط	Dat	_	>
												QA Closed:	Dat	e:	
Vork Ord	er:						DISPOSITION			AGAI	NST DE	PARTMENT	PROCESS		,
	•						Rework	7		Skid-tube Crosst	ube	]	Water Jet		Engineering
Part	No.				o¥		Scrap	]	ļ	Machining Small	Fab	Pro	d. Eng. Coor.		Quality
*** *							Use-as-is		Thern	noforming Finish	- J	Rec/Stor	e/Packaging	_	Other
NCR	No.					-	Work Order Update			Large Fab Compo	site	]	Supplier		
Root					Des	scrip	ption of work order update	T	Initial	Action		Sign &		$\Box$	
Cause		Date	Step	Qty		C	or Non-conformance	Ct	nief Eng	Description		Date	Verification	<u> </u>	QC Inspector
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	-	Bending			0 /6	-	Bend	-	Grain		-	Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to	0/5	$\vdash$	BOM/Route	-	Hardwa		-	Over/Under			Temperature/Cure
	-	Cracks	C			-	Broken/Damaged	$\vdash$	4 '	ion Incomplete	-	Part Incorred			Weld
	-	Crushed/	crimpea.	-		$\vdash$	Burrs	-	-1	ions Incomplete/Unclear	-	Part Lost/Mi	issing		Wrong Stock Pulled
	-	Cuffs Heat Trea				-	Contamination Countersink	$\vdash$	Mainte Mislabe		-	Part Moved	Mrong	,	
	$\vdash$	Inspection		Tubo		-	Cut Too Short	-	Misrea		-	Positioned V Power Loss/		$\overline{}$	Other
	$\vdash$	Ripples in	•	rube		-	Drill Holes	$\vdash$	Offset			Trower ross/	Juige		Other
	$\vdash$	Torque W		Evtrucio	n	-	Drawing		4	Calibration		<u> </u>			
	$\vdash$	Turning S			11	$\vdash$		$\vdash$	4			<del></del>			
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Outside Dimensions

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Wave/Twist in Tube

## 6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

X	Qty	Qty	Qty	Qty	Qty	Qty		
X   D412-698-012   CABIN DOOR ROLLER KIT, RH	-011	-012	-013	-017	-019	-021	Part Number	Description
X	X							
X		Х						
X			Х					
X   D412-698-021   REPLACEMENT SHIM KIT				X				and the same of th
3   3   D3121-141   BRACKET ASSEMBLY     1	14				X		D412-698-019	BEARING OVERHAUL KIT
D3121-143   BRACKET ASSEMBLY						Х	D412-698-021	REPLACEMENT SHIM KIT
1	3	3					D3121-141	BRACKET ASSEMBLY
1         1         D3137-043         BRACKET ASSEMBLY           1         D3183-043         BRACKET ASSEMBLY           9         9         D3183-044         BRACKET ASSEMBLY           9         9         D3199-1         BRACKET           1         1         D3202-1         COVER           4         D3203-1         HANDLE           1         D3220-041         DOUBLER           1         D3220-042         DOUBLER           2         D3220-3         DOUBLER           2         D3121-21         BOLT           5         D3121-241         BEARING ASSEMBLY           71         D3137-5         WASHER           2         D3238-1         SHIM           3         D3238-3         SHIM           4         D3238-1         SHIM           5         D3238-1         SHIM           4         D3238-15         SHIM           8         AN960JD416L         WASHER           MS21042L4         NUT (OR MS21042-4)								BRACKET ASSEMBLY
1         1         D3137-043         BRACKET ASSEMBLY           1         D3183-043         BRACKET ASSEMBLY           9         9         D3183-044         BRACKET ASSEMBLY           9         9         D3199-1         BRACKET           1         1         D3202-1         COVER           4         D3203-1         HANDLE           1         D3220-041         DOUBLER           1         D3220-042         DOUBLER           2         D3220-3         DOUBLER           2         D3121-21         BOLT           5         D3121-241         BEARING ASSEMBLY           71         D3137-5         WASHER           2         D3238-1         SHIM           3         D3238-3         SHIM           4         D3238-1         SHIM           5         D3238-1         SHIM           4         D3238-15         SHIM           8         AN960JD416L         WASHER           MS21042L4         NUT (OR MS21042-4)	<u> </u>	1					D3121-144	BRACKET ASSEMBLY
1	1							BRACKET ASSEMBLY
1         D3183-044         BRACKET ASSEMBLY           9         9         D3199-1         BRACKET           1         1         D3202-1         COVER           4         D3203-1         HANDLE           1         D3220-041         DOUBLER           1         D3220-042         DOUBLER           2         D3220-3         DOUBLER           2         D3121-21         BOLT           5         D3121-241         BEARING ASSEMBLY           71         D3137-3         GUIDE           1         D3183-045         BEARING ASSEMBLY           2         D3183-045         BEARING ASSEMBLY           3         D3238-1         SHIM           1         D3238-3         SHIM           2         D3238-1         SHIM           3         D3238-11         SHIM           4         D3238-15         SHIM           8         AN960JD416L         WASHER           MS21042L4         NUT (OR MS21042-4)							D3183-043	BRACKET ASSEMBLY
1 1 1 D3202-1 COVER  4 D3203-1 HANDLE  1 D3220-041 DOUBLER  1 D3220-042 DOUBLER  2 D3220-3 DOUBLER  77 D3121-21 BOLT  5 D3121-241 BEARING ASSEMBLY  71 D3137-3 GUIDE  71 D3137-5 WASHER  2 D3183-045 BEARING ASSEMBLY  3 D3238-1 SHIM  1 D3238-3 SHIM  2 D3238-1 SHIM  2 D3238-1 SHIM  3 D3238-1 SHIM  4 D3238-15 SHIM  8 AN960JD416L WASHER  8 MS21042L4 NUT (OR MS21042-4)	<del> </del>	1						
1       1       D3202-1       COVER         4       D3203-1       HANDLE         1       D3220-041       DOUBLER         1       D3220-042       DOUBLER         2       D3220-3       DOUBLER         2       D3121-21       BOLT         5       D3121-241       BEARING ASSEMBLY         71       D3137-3       GUIDE         71       D3137-5       WASHER         2       D3183-045       BEARING ASSEMBLY         3       D3238-1       SHIM         1       D3238-3       SHIM         2       D3238-11       SHIM         4       D3238-13       SHIM         3       D3238-15       SHIM         4       D3238-15       SHIM         8       AN960JD416L       WASHER         MS21042L4       NUT (OR MS21042-4)	9	9		9			D3199-1	BRACKET
1				1			D3202-1	COVER
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1 D3220-042 DOUBLER D3220-3 DOUBLER D3121-21 BOLT D3121-241 BEARING ASSEMBLY D3137-3 GUIDE D3137-5 WASHER D31383-045 BEARING ASSEMBLY  3 D3238-1 SHIM D3238-3 SHIM D3238-1 SHI	<u> </u>						<del></del>	
D3220-3 DOUBLER    77	<u> </u>							
77							L	
D3121-241   BEARING ASSEMBLY   D3137-3   GUIDE								
71								
D3137-5					1.7			
2 D3183-045 BEARING ASSEMBLY  3 D3238-1 SHIM  1 D3238-3 SHIM  2 D3238-5 SHIM  6 D3238-11 SHIM  2 D3238-13 SHIM  2 D3238-13 SHIM  4 D3238-15 SHIM  8 AN960JD416L WASHER  8 MS21042L4 NUT (OR MS21042-4)								
3 D3238-1 SHIM 1 D3238-3 SHIM 2 D3238-5 SHIM 6 D3238-11 SHIM 2 D3238-13 SHIM 2 D3238-13 SHIM 4 D3238-15 SHIM 8 AN960JD416L WASHER 8 MS21042L4 NUT (OR MS21042-4)					8			
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6 D3238-11 SHIM 2 D3238-13 SHIM 4 D3238-15 SHIM 8 AN960JD416L WASHER 8 MS21042L4 NUT (OR MS21042-4)						1	D3238-3	SHIM
2 D3238-13 SHIM 4 D3238-15 SHIM  8 AN960JD416L WASHER 8 MS21042L4 NUT (OR MS21042-4)						2	D3238-5	SHIM
2 D3238-13 SHIM 4 D3238-15 SHIM  8 AN960JD416L WASHER 8 MS21042L4 NUT (OR MS21042-4)						6	D3238-11	SHIM
4 D3238-15 SHIM  8 AN960JD416L WASHER  8 MS21042L4 NUT (OR MS21042-4)						2	D3238-13	SHIM
8 MS21042L4 NUT (OR MS21042-4)						4	D3238-15	SHIM
8 MS21042L4 NUT (OR MS21042-4)			8				AN960JD416L	WASHER
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/ 1 MS24694-S101—-SCREW			<del></del>		1 1			

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Revision: **E** 

Date: 08.05.01